

WHAT IS CLAIMED IS:

- 1. A method for manufacturing an insert for a combustion head gasket includes the steps of: (a) providing a mold apparatus having an upper mold section and a lower mold section, said lower section defining a cavity adapted to receive a blank metal substrate; (b) placing a metal substrate into said cavity; (c) closing said upper mold section against the substrate to hold the insert in place under a first applied force; (d) applying a second force greater than the first to shape the insert; (e) supplying elastomeric material to selected predetermined portions of the blank metal substrate; and (f) curing the elastomeric material.
- 2. The method of claim 1 wherein said insert is adapted to seal an engine oil flow aperture of said combustion head gasket, said insert including a body portion adapted for registration with the oil flow aperture.
- 3. The method of claim 2 wherein said insert comprises a metallic body and includes an elastomeric sealing bead bonded to said body, wherein said body is plastically deformed via said application of said second force to shape said insert.
- 4. The method of claim 3 wherein said insert is manufactured in a single mold process that includes said shaping of said insert body and said molding of said bead.
- 5. The method of claim 4 wherein said elastomeric sealing bead bonded to said body comprises a sealing portion disposed about a peripheral edge of said body portion of said insert body.
 - 6. The method of claim 5 wherein said sealing body portion of said insert defines a closed loop, and wherein said insert further comprises radially extending arms provided for attachment of said insert to a combustion head gasket.

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1	7.	The method of claim 6 wherein at least one of said arms comprises an
2	offset elbow.	

- 8. The method of claim 7 wherein said elbow provides a connection between said arm and a shoulder portion of said insert, wherein said shoulder portion is contiguous with said peripheral edge of said closed loop portion of said insert.
- 1 9. The method of claim 8 wherein said closed loop is generally non-2 circular.
 - 10. The method of claim 9 wherein said mold apparatus comprises die inserts for forming said insert.